

Date: Thursday, 26/06/2008 3:07:47 PM  
User: Melanie Fauteux

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206B UTILITY BASKET
<b>Job Number</b> :	40127		
<b>Estimate Number</b> :	11282		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206540013
<b>This Issue</b> :	26/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D206-540 /DSI9361
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	39733	<b>Drawing Revision</b> :	I / A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :		<b>Due Date</b> :	11/07/2008
<b>Comment</b> :	Est Rev:I Revised as per Rev I 05-12-07 JLM Est Rev:J reformat 06.04.04 EC Est Rev:K 07-03-20 As per DSI9361 JLM		
<b>Type</b> :	LARGE FAB ASSY		
<b>Qty:</b>	1	<b>Um:</b>	Each

**Additional Product**

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
		
	<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile & type labels per PPPD206-540-013 CHG005 <i>S 08/07/08</i>	
2.0	PACKAGING 1	PACKAGING RESOURCE #1
		
	<b>Comment:</b> PACKAGING RESOURCE #1 Pick: Assembly Kit	
3.0	40127A	206B BASKET LID - UNDER REVIEW <i>pt 08.06.27</i>
		
	<b>Comment:</b> Sub-Component 206B BASKET LID 1 x D2330-043 Batch <del>401</del> <i>40127A</i> <i>EP 08/07/08</i>	
4.0	40127B	206B BASKET BASE - UNDER REVIEW <i>pt 08.06.27</i>
		
	<b>Comment:</b> Sub-Component 206B BASKET BASE 1 x D2330-041 Batch <i>40127B</i> <i>EP 08/07/08</i>	
5.0	D2332041	Lid Prop Assembly 6.69" long
		
	<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Assembly Kit Qty Part Number Description Batch 1 D2332-041 Prop Ass'y <i>38797</i> <i>EP 08/07/08</i>	

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2022-101 SPACER 37521

*Lu*

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B37853

*Lu*

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring 37071

*Lu*

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing 39153

*Lu*

10.0

D2931

Bumper



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 D2931 Bumper 21139

*Lu*

11.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS20600AD4W3 Rivet 18071

*Lu* 8/2/12

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Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-7A Bolt M107321

*[Signature]*

13.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-24A Bolt M104547

*[Signature]*

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M107737

*[Signature]*

15.0

D27283

Dart Logo Label - large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Dart Logo label large

Batch: 22553

*[Signature]*

16.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 AN4-22A Bolt M104937

*[Signature]*

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M106815

*[Signature]* 8/2/70

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Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

AN960JD416 Washer M107939

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

M108138

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M107909

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M108077

22.0

AN960JD8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD8 Washer M107600

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M107665

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Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L4

Nut (or -4)

*M107478*

*LU*

25.0

D2258170

Label - 170 lb



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2258-170

Placard

*B16 266*

*E 8/7/7*

*Last Page*

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D206-540

*08/07/08 @*

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/08/08 @*

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

29.0

D2249041

Fitting Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2249-041

Braket

*34671*

*SC*

~~29.0~~

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 MS21042L5

Nut (or -5)

*M107935*

*8/7/8*

*(X)*

*SL*

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:	Machine Or Operation:	Description :
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31.0	D33963	Spacer
------	--------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

Batch: 36336

32.0	D2022101	Spacer
------	----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

4 D2022-101 Spacer

37521

33.0	D2012107	Clevis
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2012-107 Clevis

33588

34.0	D2259	Label
------	-------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 D2259 Placard

110671

35.0	D2525	Spacer
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2525 Spacer kit

34506

36.0	D2526	Bushing
------	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2526 Bushing

27055

37.0	D2748	Clevis
------	-------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 D2748 Clevis

34511

*Handwritten signature and date: 8/7/08*

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Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

D27491

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-1 Strut

23423

*[Signature]*

39.0

D27493

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

1 D2749-3 Strut

23424

*[Signature]*

40.0

D2814

Strut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 D2814 Strut

B25096 1x B38779

*[Signature]*

41.0

AN412A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-12A

Bolt

M105143

*[Signature]*

42.0

AN412

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Packing Kit

2 AN4-12 Bolt

M104016

*[Signature]*

43.0

AN45A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

8 AN4-5A Bolt

M106605

*[Signature]*

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Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

44.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN5-17A Bolt

M106818

LC

45.0

AN421A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN4-21A Bolt

M11698

LC

46.0

AN960JD416

Washer



Comment: Qty.: 19.0000 Each(s)/Unit Total : 19.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

19 AN960JD416 Washer

M107939

LC

47.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 AN960JD516 Washer

M107959

LC

48.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN970-4 Washer

M108077

LC

49.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4)

M107478

LC 8/2/0



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Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

50.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

2 MS21042L5 Nut

M107339

LC

51.0

MS27039411

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 MS27039-4-11 Screw

M3355

LC

52.0

AN46

Bolts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

1 AN4-6 Bolt

M9599

LC

53.0

AN3204

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN320-4 Nut

M7195

LC

54.0

AN38022

Cotter Pins



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick: Packing Kit

3 AN380-2-2 Cotter pin

M16895

LC

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

808/04/08

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-540-013

Location:

PPP Rev:

RE

LC

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B UTILITY BASKET

Job Number: 40127

Part Number: D206540013

Job Number:



Seq. #:

Machine Or Operation:

Description :

57.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*mF 08-07-08*

**DART**

DESIGN KE	DRAWN BY MB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 1 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION	SCALE NTS
C	94.07.28	REVISED DRAWING	
D	94.11.12	ADDED D2323 STRUT	
E	94.11.12	CHANGED SECTION C-C	
F	94.11.12	ADDED HANDLE AND LID PROP	
G	99.09.21	REDRAW, CHANGE LATCH/HINGE/STRUTS	
H	99.12.02	INCORPORATE DSI 9174 / DEO 9167	
I	05.11.10	REPLACED PIANO HINGE SYSTEM	

Qty -011	Qty -013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
	1	D2012-107	CLEVIS
2	6	D2022-101	SPACER
2	2	D2249-041	BRACKET
1		D2252-041	BASKET ASSEMBLY
1		D2252-043	LID ASSEMBLY
1	1	D2258-170	PLACARD
1	1	D2259	PLACARD*
	1	D2330-041	BASKET ASSEMBLY
	1	D2330-043	LID ASSEMBLY
1	1	D2332-041	LID PROP ASSEMBLY
2	2	D2525	SPACER KIT
2	2	D2526	BUSHING
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2748	CLEVIS
	1	D2749-1	STRUT
	1	D2749-3	STRUT
1		D2749-5	STRUT
1		D2749-7	STRUT
	2	D2814	STRUT
4	4	D2931	BUMPER
2	2	AN3-16A	BOLT
	3	AN320-4	NUT
	3	AN380-2-2	COTTER PIN
	2	AN4-12	BOLT
2	2	AN4-12A	BOLT
2	2	AN4-21A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
8	8	AN4-5A	BOLT
	1	AN4-6	BOLT
2	2	AN4-7A	BOLT
6	6	AN5-17A	BOLT
16	23	AN960JD416	WASHER
6	6	AN960JD516	WASHER
4	4	AN960JD8	WASHER
4	5	AN970-4	WASHER
4	4	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
8	8	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
	1	MS27039-4-11	SCREW

\*NOTE: Placard D2259 to be installed in cock pit near the airspeed indicator.

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40127



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D206-540	REV. 1 SHEET 2 OF 8
DATE 05.11.10		TITLE UTILITY BASKET INSTALLATION SCALE NTS	

## WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D206-540-011	70 lb	40.0 in	2800 in-lb	111.0 in	7770 in-lb
206 L Series Basket Installation	31.8 kg	1.0 m	31.8 m-kg	2.8 m	89.0 m-kg
D206-540-013	50 lb	40.0 in	2000 in-lb	99.0 in	4950 in-lb
206 A/B Series Basket Installation	22.7 kg	1.0 m	22.7 m-kg	2.5 m	56.8 m-kg

## GENERAL NOTES

### COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification. This basket can only be installed on the starboard side of the aircraft on high gear. Ensure that any steps that are outboard of the crosstubes are removed.

### WORKMANSHIP

Unless otherwise stated, all workmanship should be to the standard set by the Aircraft Maintenance Manual.

### CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Maintenance Manual Supplement  
**MMS-D206-540.**

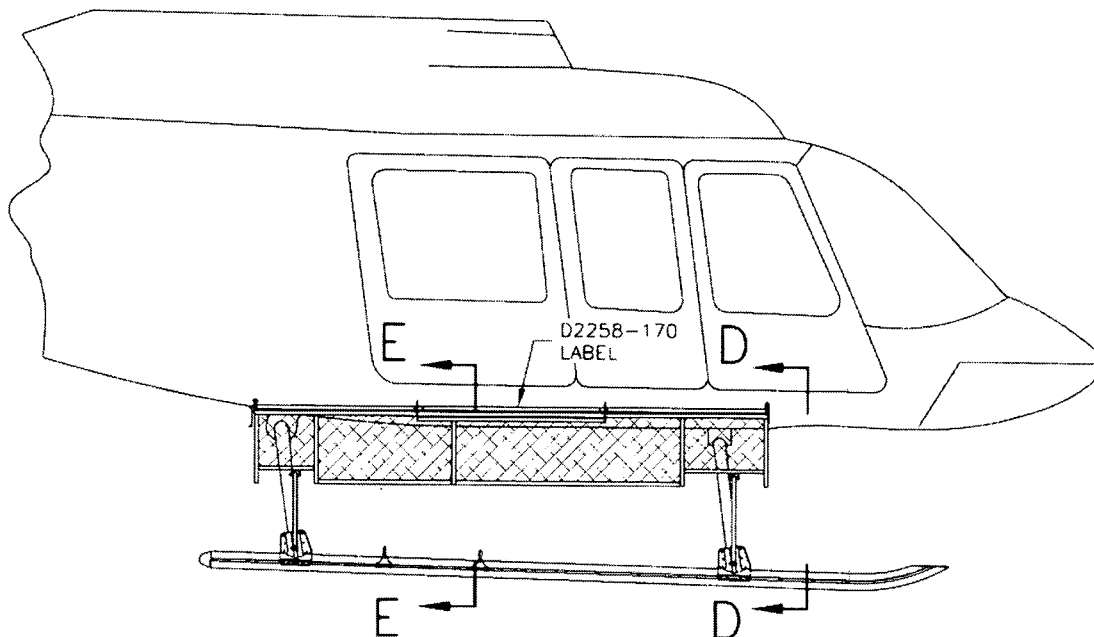
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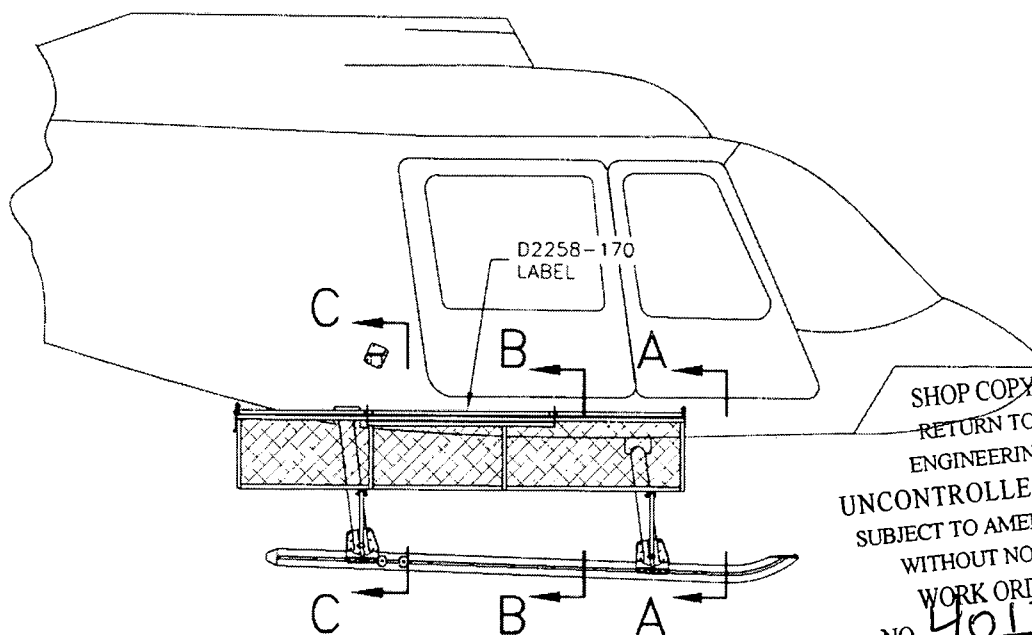
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



D206-540-011 206L/L1/L3/L4 BASKET INSTALLATION



D206-540-013 206A/B BASKET INSTALLATION

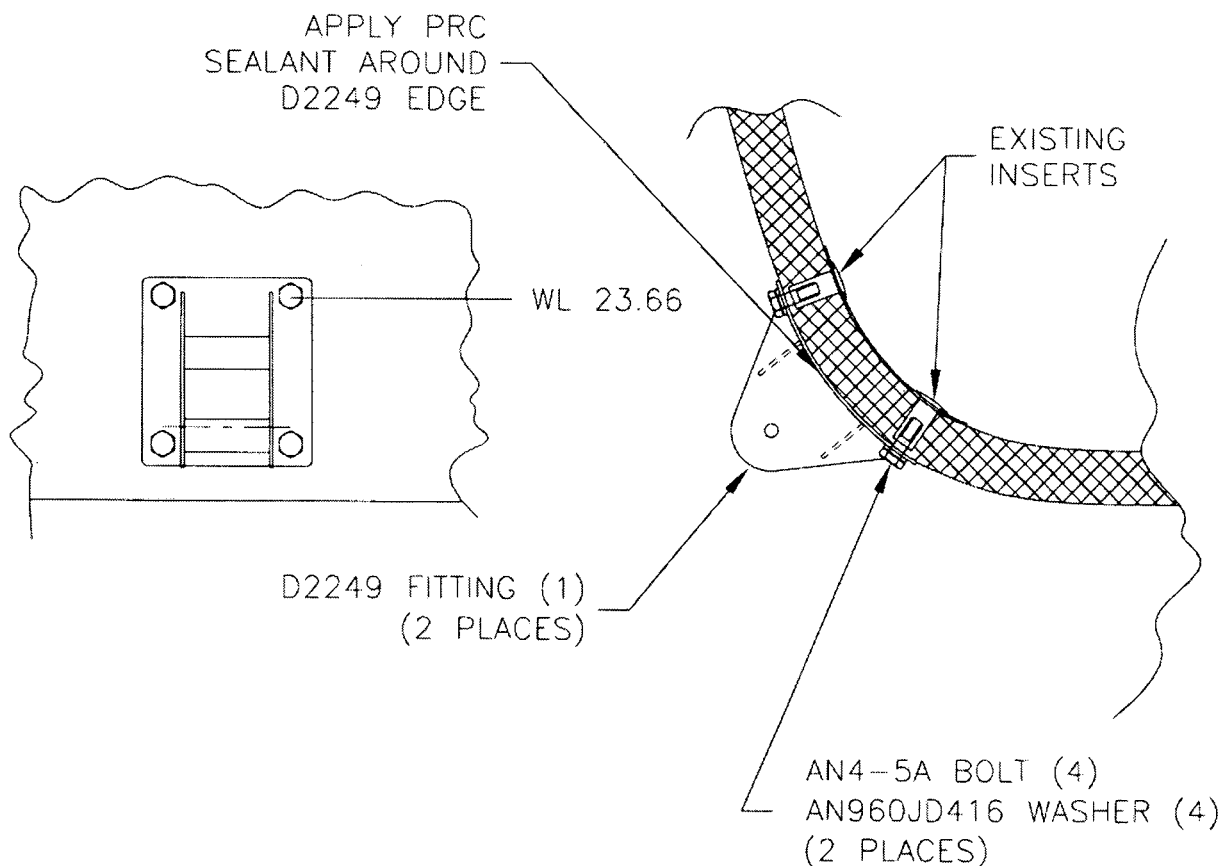
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO D206-540	REV. 1 SHEET 4 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



BRACKET DETAIL

REPLACE 206-031-370-6  
AND 206-031-370-8 STEPS AS  
REQUIRED WITH D2249 FITTINGS.  
REFER TO SERVICE INSTRUCTION  
BHT-206-SI-22

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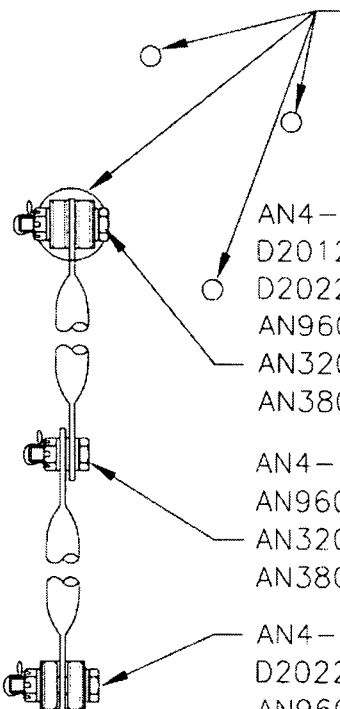
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CHECKED 	APPROVED 	DRAWING NO D206-540	REV. 1 SHEET 5 OF 8
DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS

MOUNT TO AFT MOST  
INSERT LOCATION (EXISTING)



AN4-12 BOLT (1)  
D2012-107 CLEVIS (1)  
D2022-101 SPACER (2)  
AN960JD416 WASHER (2)  
AN320-4 NUT (1)  
AN380-2-2 COTTER PIN (1)

AN4-6 BOLT (1)  
AN960JD416 WASHER (3)  
AN320-4 NUT (1)  
AN380-2-2 COTTER PIN (1)

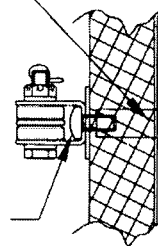
AN4-12 BOLT (1)  
D2022-101 SPACER (2)  
AN960JD416 WASHER (2)  
AN320-4 NUT (1)  
AN380-2-2 COTTER PIN (1)

\*NOTE: DO NOT OVERTIGHTEN NUTS,  
ALLOW STRUTS TO ROTATE

\*\*NOTE: D2022-101 SPACERS CAN BE  
REPOSITIONED TO LINE-UP STRUT

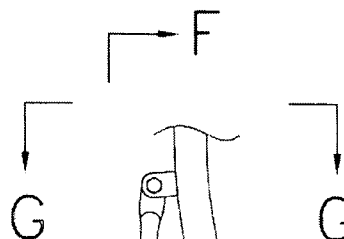
SECTION F-F

EXISTING  
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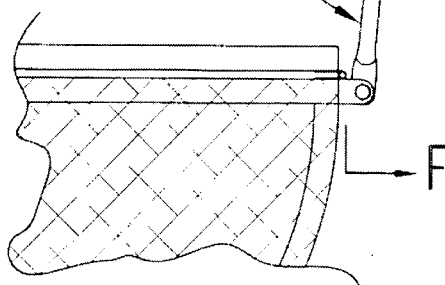


MS27039-4-11 SCREW (1)  
D2012-107 CLEVIS (REF)  
AN970-4 WASHER (1)

SECTION G-G



D2814 STRUT (2)



SECTION C-C

D206-540-013 (206 A/B) ONLY

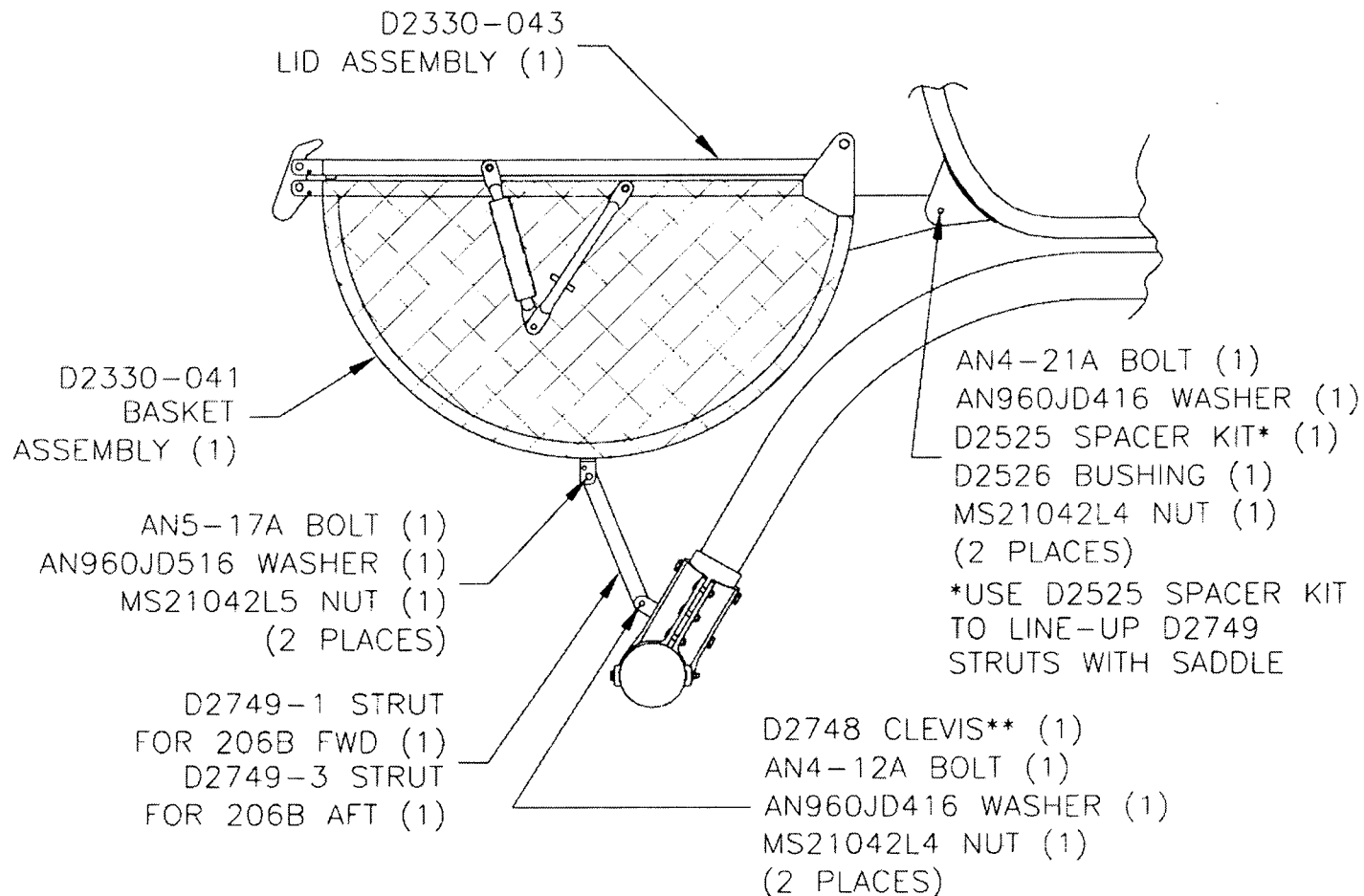
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DATE	05.11.10	DRAWING NO	D206-540	REV. 1
		TITLE	UTILITY BASKET INSTALLATION	SHEET 6 OF 8
		SCALE	NTS	



\* NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748  
CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE



SECTION A-A AND B-B

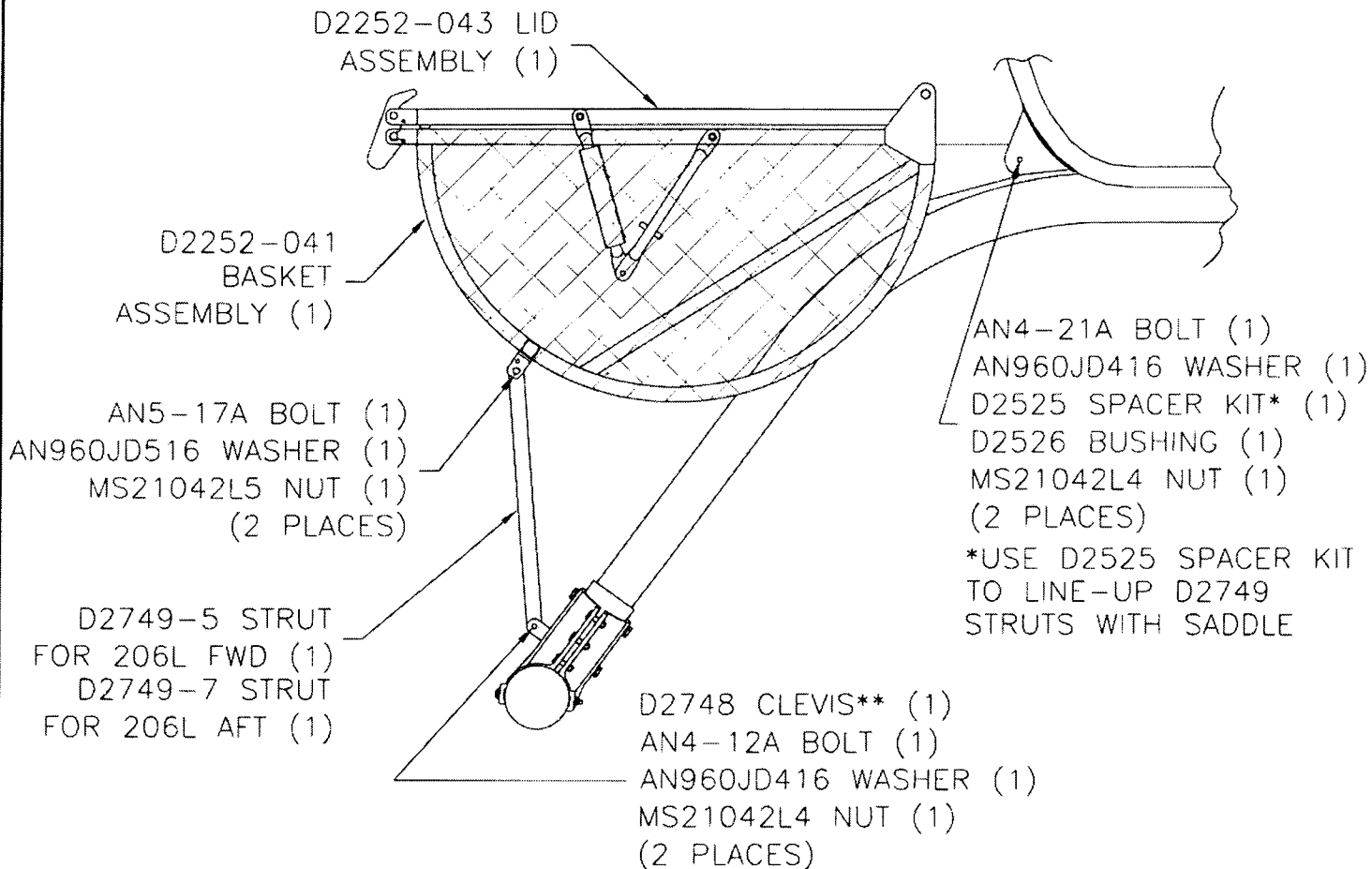
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		D206-540	SHEET 7 OF 8
DATE	TITLE	SCALE	
05.11.10	UTILITY BASKET INSTALLATION	NTS	



\*\*NOTE: REPLACE EXISTING SADDLE WASHER WITH D2748 CLEVIS AND RE-ATTACH USING EXISTING SADDLE HARDWARE

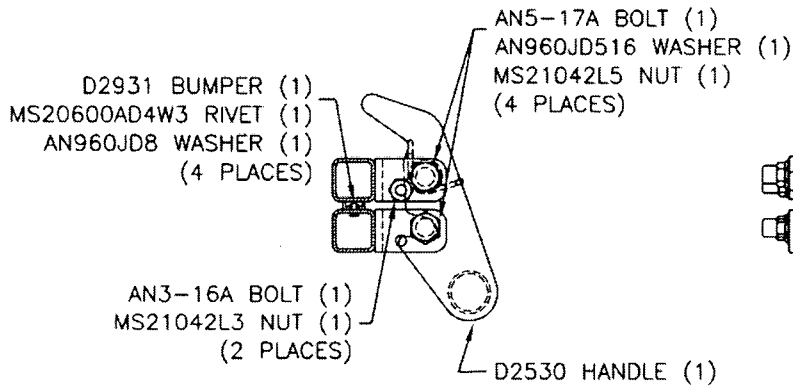
SECTION D-D AND E-E

D206-540-011 (206 L/L1/L3/L4) ONLY

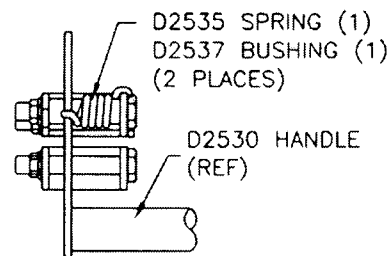
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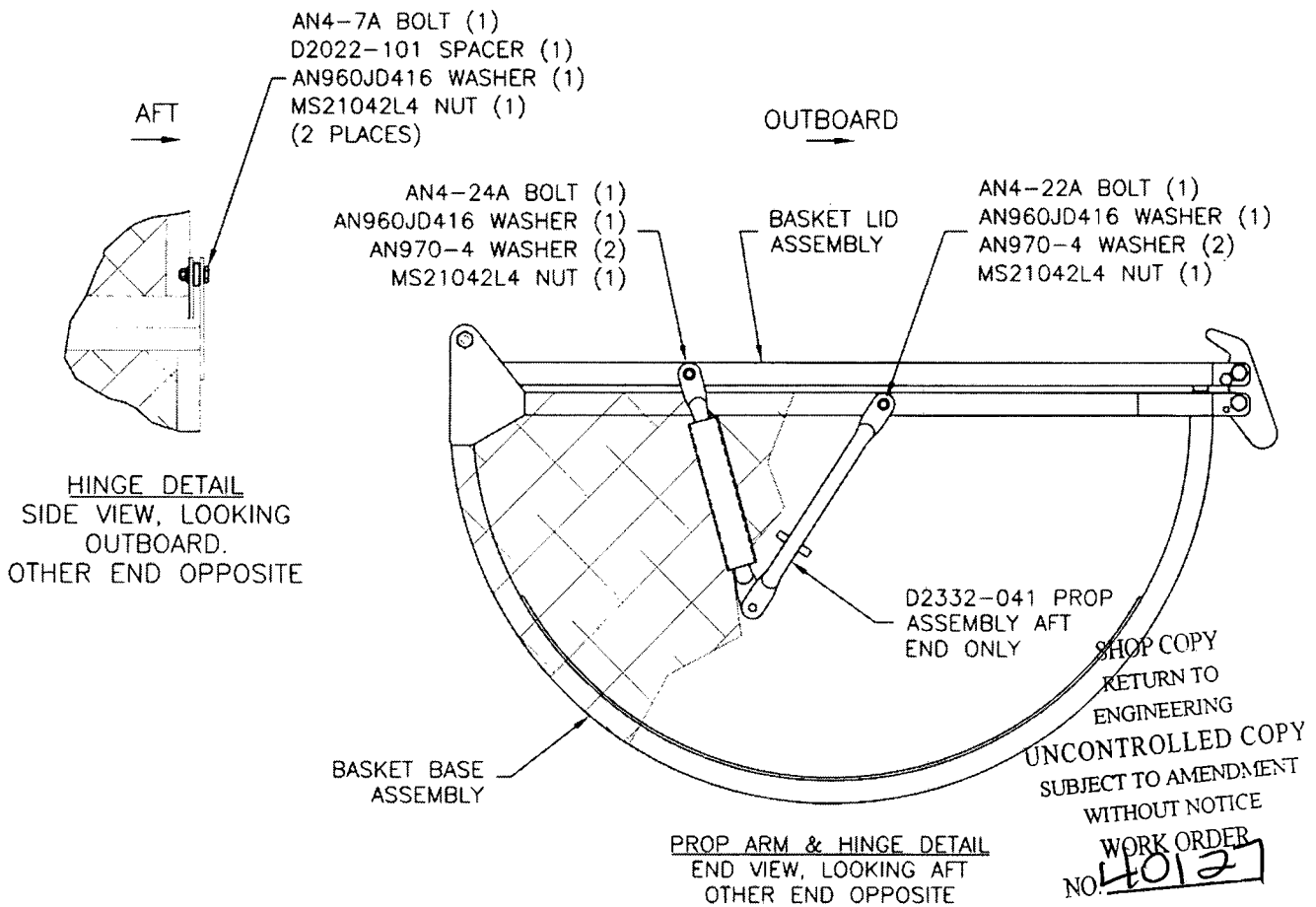
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DATE 05.11.10	TITLE UTILITY BASKET INSTALLATION		SCALE NTS



LATCH DETAIL



SPRING DETAIL



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CHECKED <b>B</b>	APPROVED <b>#</b>	DRAWING NO. DSI 9361	REV. A SHEET 1 OF 1
DATE 07.03.15		TITLE UTILITY BASKET SPACER	SCALE NTS
A	07.03.15	NEW ISSUE	

## **DART SERVICE INSTRUCTION**

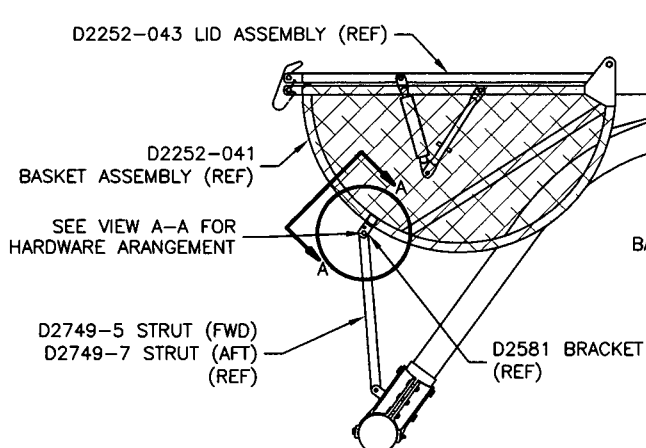
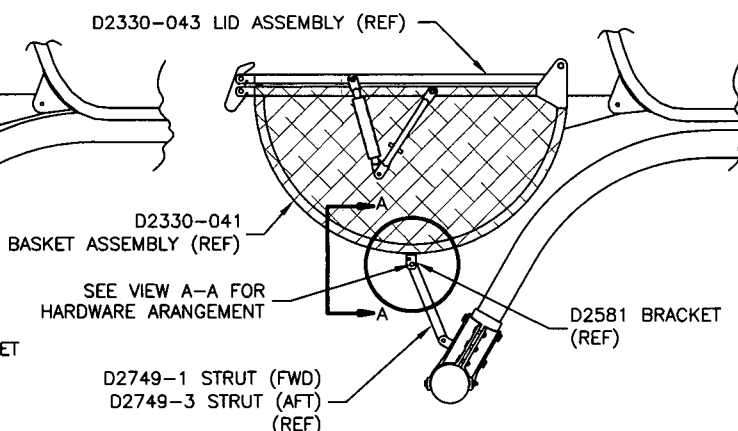
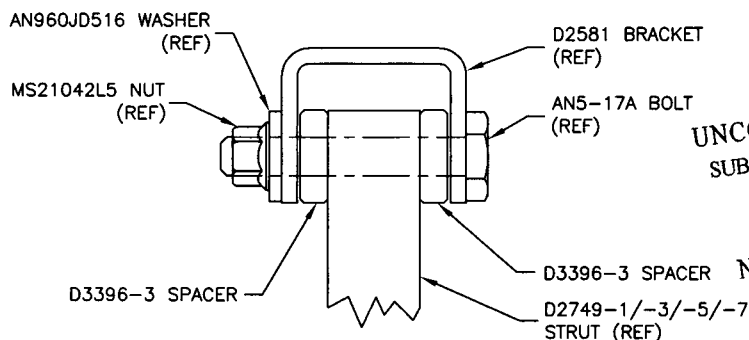
TO AMEND DART INSTALLATION DRAWING D206-540 REV. I

REF. CANADIAN STC: SH94-5

REF. FAA STC: SR00386NY

The following parts will be **added** to the Parts List on page 1 of Installation Drawing D206-540.

Qty - 011	Qty - 013	Part No.	Description
X		D206-540-011	BASKET INSTL'N - BELL 206L/L1/L3/L4
	X	D206-540-013	BASKET INSTL'N - BELL 206A/B
4	4	D3396-3	SPACER

Install qty(2) D3396-3 Spacers per strut at the location shown in **Figure 1** (for D206-540-011 kit) and **Figure 2** (for D206-540-013 kit). Install hardware per View A-A**FIGURE 1 - D206-540-011  
INSTALLATION****FIGURE 2 - D206-540-013  
INSTALLATION****VIEW A-A - HARDWARE  
ARRANGEMENT (TYP)**

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CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
<b>APPROVED</b>	
BY:	<i>[Signature]</i> D. SHEPHERD (DE # 02)
DATE:	07.03.15
CERT. NO.:	SH94-5
ISSUE NO.:	4

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08/07/08	25b	<del>add</del> <del>MS 21042L5</del> <del>W 107939</del> Move to step 25	EB	08/07/08	4	EB	EB	

Part No: D 206-540-013 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>40127</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 26/06/2008 3:09:33 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206B BASKET LID - UNDER REVIEW  
 Job Number : 40127A *PD 01.06.27*  
 Estimate Number : 11280  
 P.O. Number : Part Number : D2330043  
 This Issue : 26/06/2008 S.O. No. : Drawing Number : D2330 REVE  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : / / Type : LARGE FAB ASSY Drawing Revision : E  
 Previous Run : 39733A Material :  
 Written By : Due Date : 11/07/2008 Qty: 1 Um: Each  
 Checked & Approved By :  
 Comment : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K  
 J

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
	<i>0.065 PD 01.06.27</i> Comment: Qty.: 23.3625 f(s)/Unit Total : 23.3625 f(s) 3/4" x 3/4" x <del>0.065</del> wall 304/316 SS tubing. Batch: <i>M108153</i> <i>SAD 08/06/30</i> (1)	
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1  1- Cut D2330-1-3-9 as per Dwg D2330  2-Drill hole in D2330-3 as per Dwg D2330  3-Deburr <i>SAD 08/06/30</i> (1)	
3.0	D22321	Basket Hinge
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-1 HINGE <i>B35684</i> <i>PD 08-07-03</i>	
4.0	D2329	Label Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2329 Label Plate <i>B35686</i> <i>PD 08-07-03</i>	

Date: Thursday, 26/06/2008 3:09:33 PM  
User: Melanie Fauteux

## Process Sheet

\*Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 40127A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23271

Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2327-1 Bushing B36920

PD 08-07-02

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Chanel B39046

PD 08-07-02

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total: 18.9000 sf(s)

Pick:

Qty Part Number Description Batch

18 sf M304EX0.75-16F Expanded Metal M108152

PD 08-07-03

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M105524

PD 08-07-03 ①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Job 0707 ①  
Pl 08-07-07

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 0707 ①

Date: Thursday, 26/06/2008 3:09:33 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET LID - UNDER REVIEW

Job Number: 40127A

Part Number: D2330043

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

(1) pressure wash

POWDER COATING

08-07-07 (X)



M107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:30pm

OVEN TEMPERATURE:

400F

FINISH TIME:

4:00pm

JH

08-07-07 (X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/07/07 (1)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

EF 08/07/08 (1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08

Job Completion



mf 08-07-08

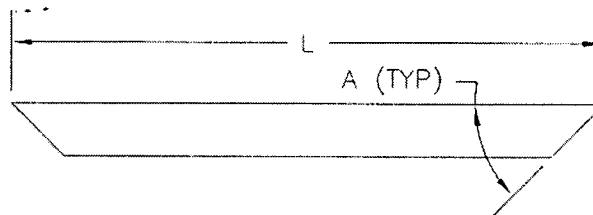


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DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.075W 0.60)
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSION ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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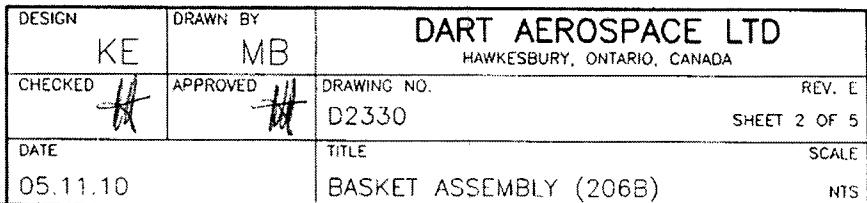
08.06.27  
UNDER REVIEW  
08.06.27  
TUBING TO BE  
CHANGED TO 0.045  
WALL

RELEASED  
05.11.26

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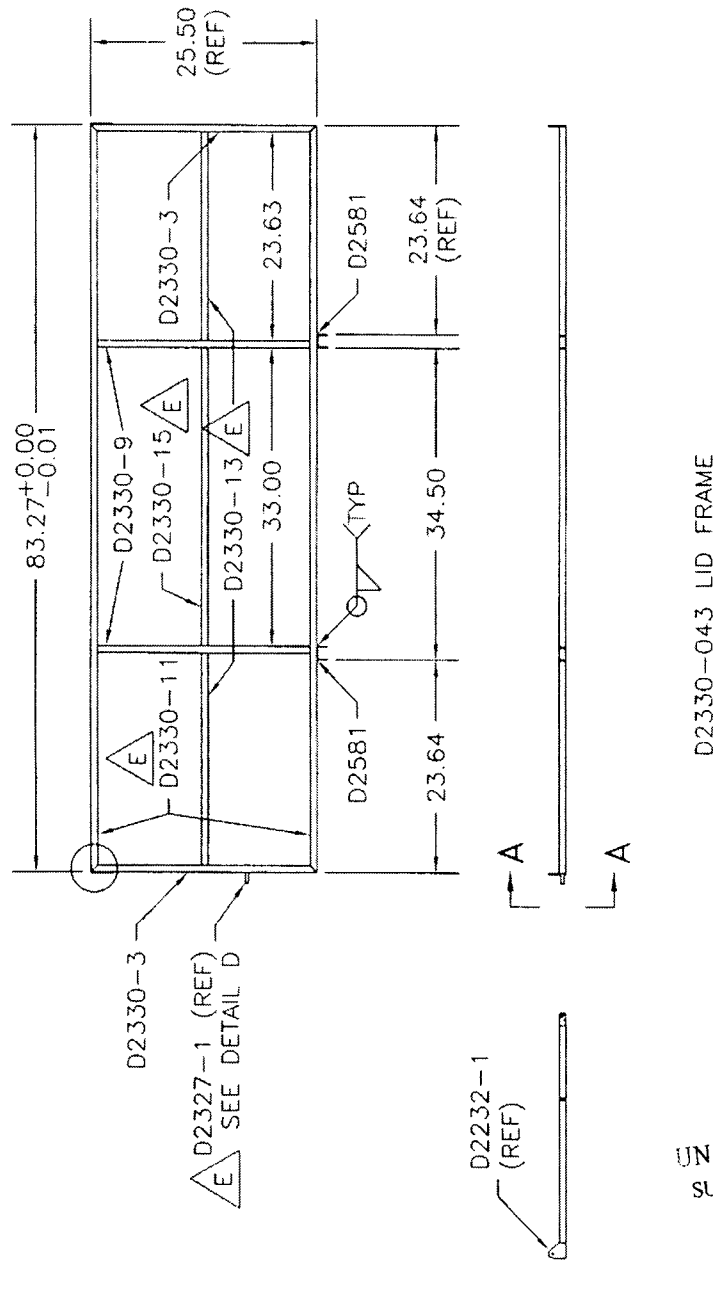




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05 11 26

**UNDER REVIEW**

~~08-02-05 PH~~  
~~TUBING TO BE~~  
~~CHANGED TO GORES~~  
~~WALL~~  
~~PH~~  
~~03-06-27~~



WELD ALL JOINTS  
AS SHOWN

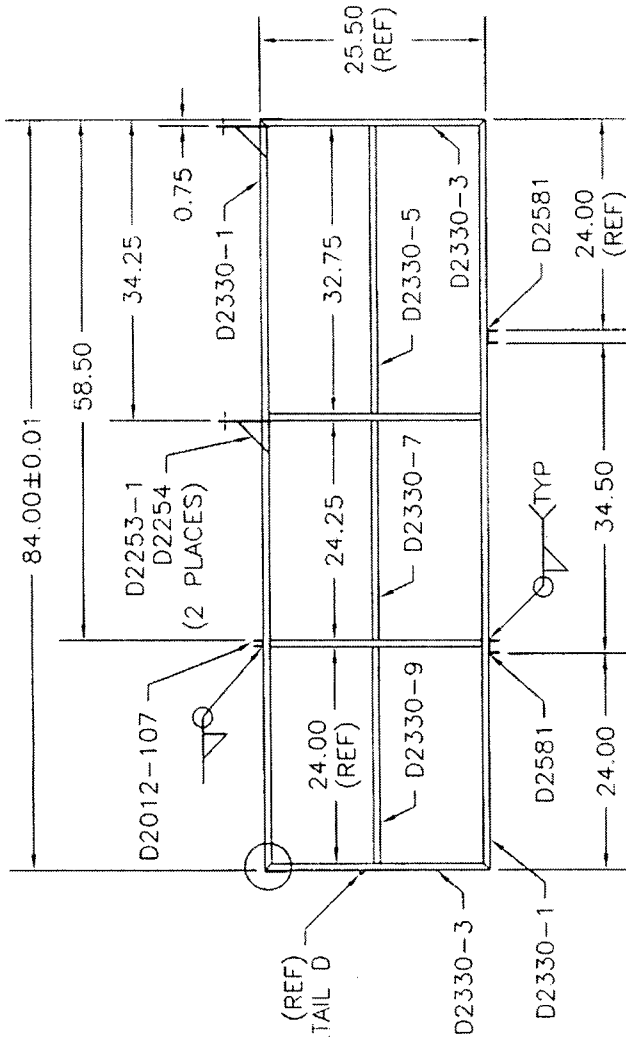
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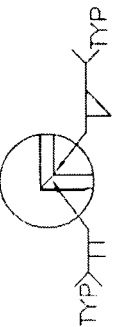
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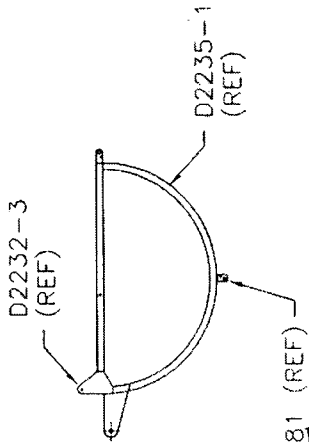
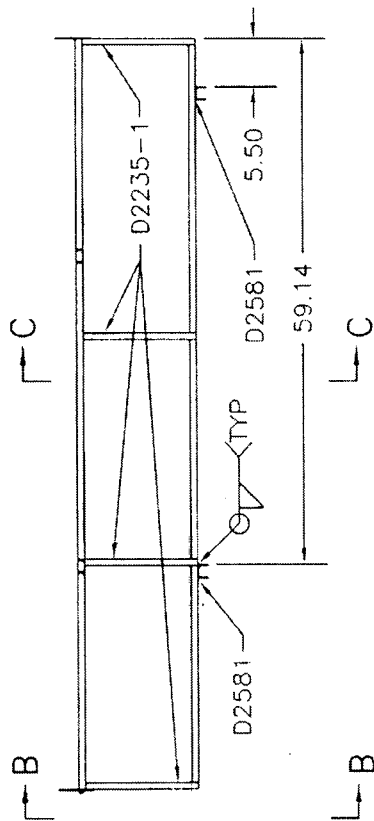
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



WELD ALL JOINTS  
AS SHOWN



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D2330-041 BASKET FRAME

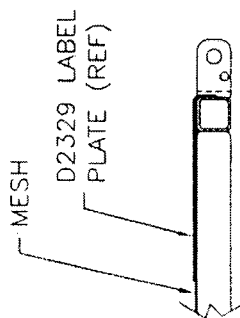
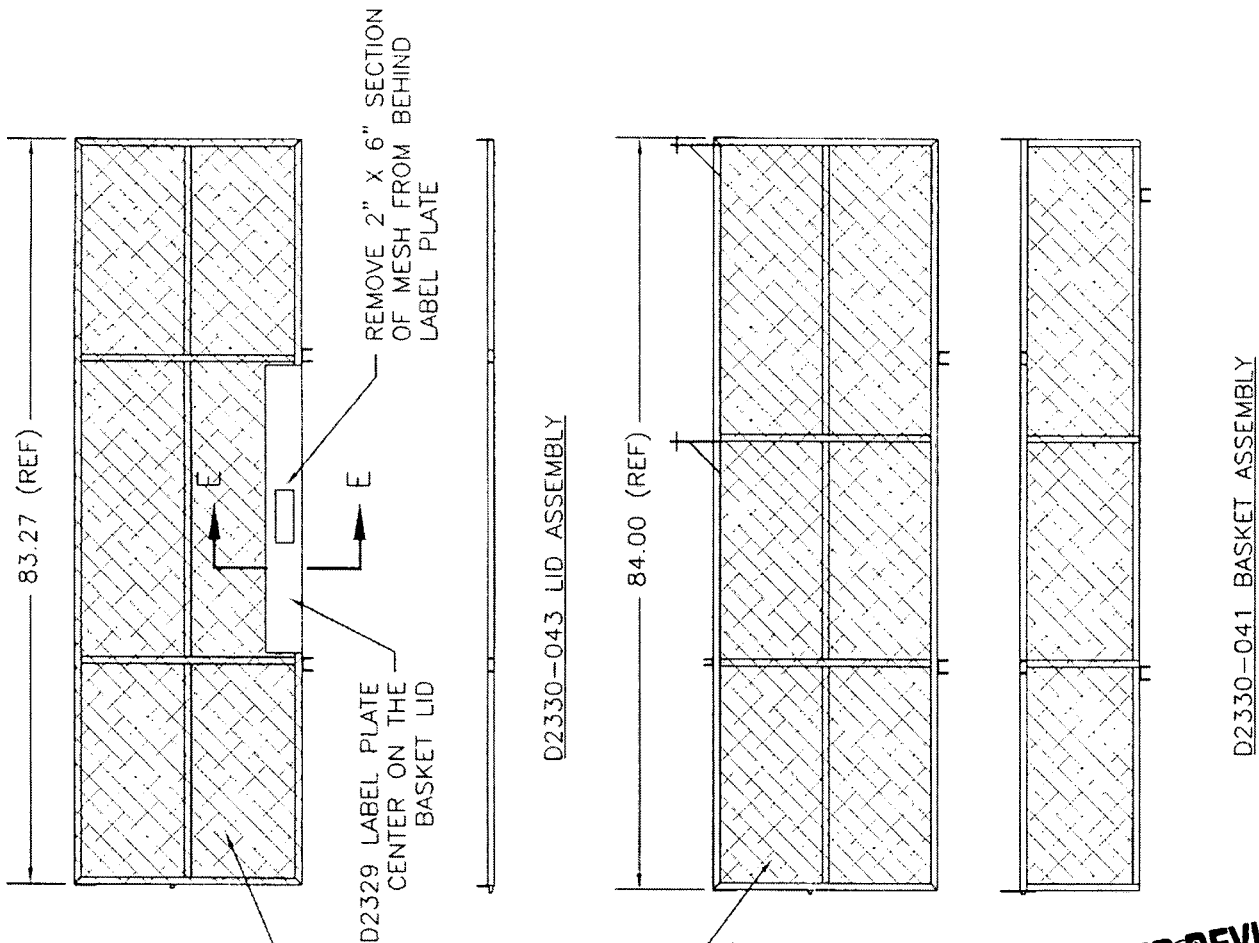
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS

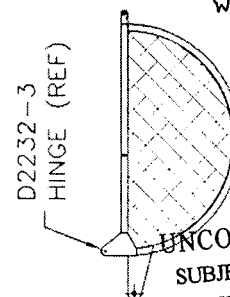


SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

**RELEASED**  
05/11/20



**UNDER REVIEW**  
08.02.06 PH  
TUBING TO BE  
CHANGED TO 0.065  
WALL

PH  
08.06.27

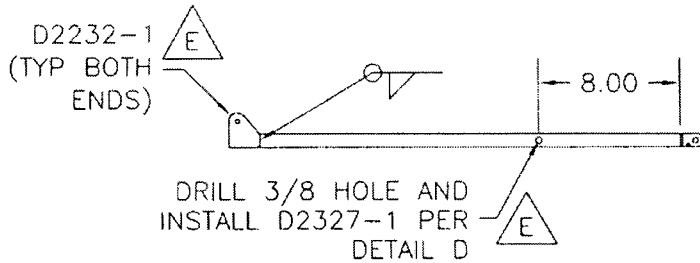
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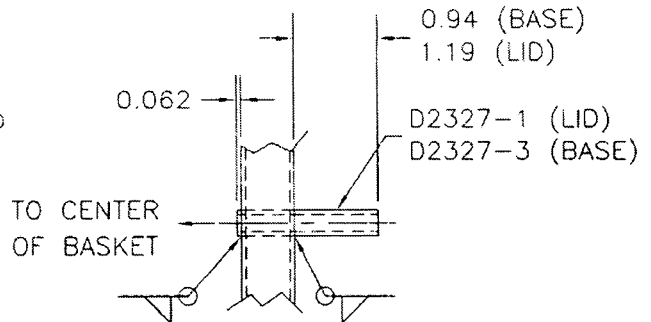
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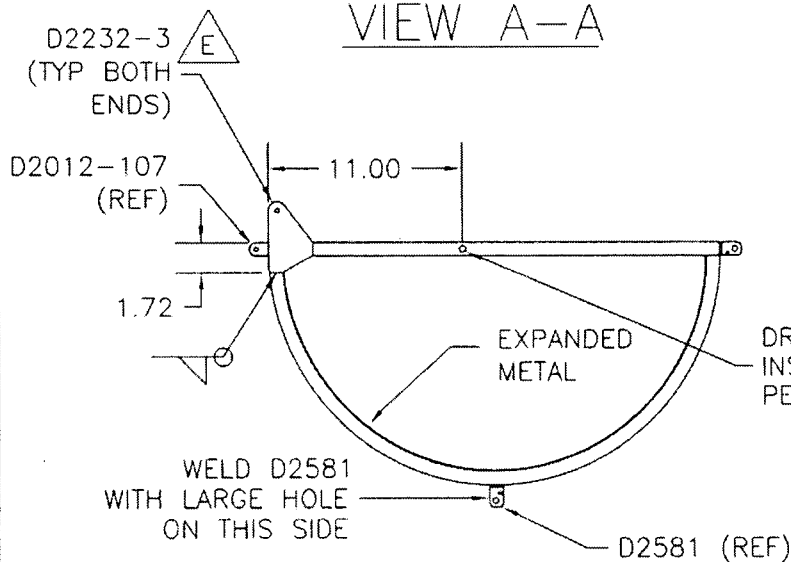
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206B)		SCALE NTS



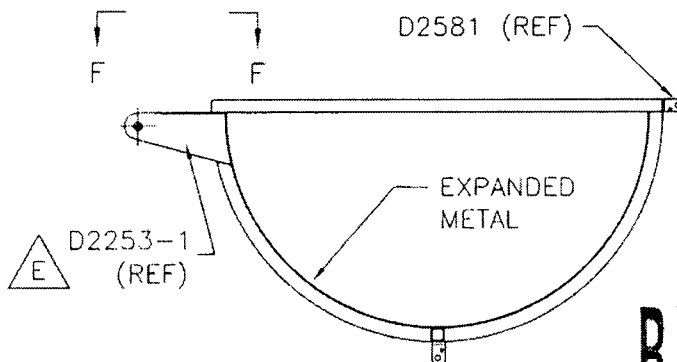
VIEW A-A



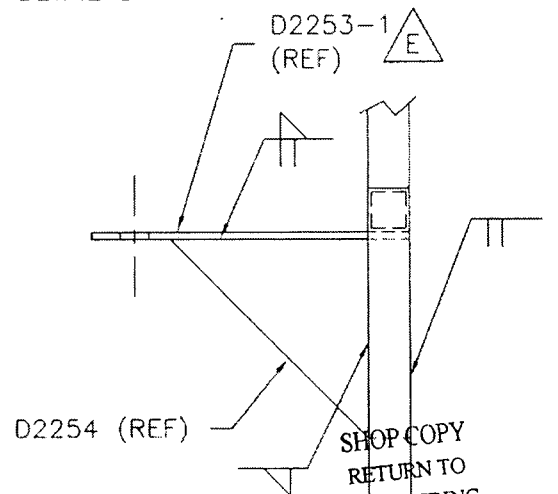
DETAIL D



VIEW B-B



VIEW C-C



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Date: Thursday, 26/06/2008 3:13:37 PM  
User: Melanie Fauteux

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 206B BASKET BASE - UNDER REVIEW <i>rd 03.06.27</i>
<b>Job Number</b> : 40127B	
<b>Estimate Number</b> : 11276	
<b>P.O. Number</b> :	<b>Part Number</b> : D2330041
<b>This Issue</b> : 26/06/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2330 REVE
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : E
<b>Previous Run</b> : 39733B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 11/07/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:H 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part#	Description	Batch
4	D3166-1	Hoop	B 39048

*B 39673*  
*B 40090*  
*B 37324*

*SAD 08/06/30*

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



**Comment:** Qty.: 25.3019 f(s)/Unit Total : 25.3019 f(s)

3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Batch: *M108153*

*SAD 08/06/30*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.

Cut 4 D2235-1 From D3166-1

2- Cut D2330-1-3-5-7-9 as per Dwg D2330

3-Drill hole in D2330-3 as per Dwg D2330

4-Deburr

*SAD 08/07/04*

4.0	D22531	Lug
-----	--------	-----



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Gusset

Batch: *335685* ✓

*rd 08/07/04*

Date: Thursday, 26/06/2008 3:13:37 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 40127B

Part Number: D2330041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2012-107	Clevis	
---	-----------	--------	--

B33585

ls 08/07/04

6.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D2327-3	Bushing	
---	---------	---------	--

337541

ls 08/07/04

7.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	D2581	Mounting Chanel	
---	-------	-----------------	--

339046

ls 08/07/04

8.0	D2254	Gussett
-----	-------	---------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2254	Lug	
---	-------	-----	--

323421

ls 08/07/04

9.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D2232-3	HINGE	
---	---------	-------	--

339334

ls 08/07/04

10.0	M304EX07516F	Expanded Metal Flat Stai
------	--------------	--------------------------



Comment: Qty.: 31.5000 sf(s)/Unit Total : 31.5000 sf(s)

Pick:



Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

30 sf	M304EX0.75-16F	Expanded Metal	
-------	----------------	----------------	--

M108152

SAS 08/07/04

(1)

Date: Thursday, 26/06/2008 3:13:38 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206B BASKET BASE - UNDER REVIEW

Job Number: 40127B

Part Number: D2330041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2330 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M10SS24

JD 08/07/07  
DD 08-07-04

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JD 08-07-07

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JD 08-07-07

14.0

POWDER COATING

+ PRESSURE WASH POWDER COATING

08-07-07



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 3:30pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 4:00pm

JD 08-07-07

(X)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/07/07 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

FD 08/07/08 @

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/08 JD

Job Completion



MF 08-07-08

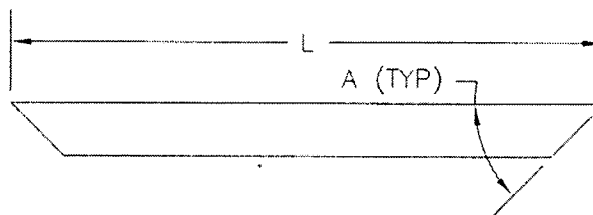
**DART**

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CHECKED H	APPROVED H	DRAWING NO. D2330	REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS
C	96.05.23	ADDED LATCH AND LABEL PLATE	
D	99.09.14	MODIFIED LATCH, REDREW	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2330-11	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2330-041	BASKET ASSEMBLY		
	X	D2330-043	LID ASSEMBLY		
1		D2012-107	CLEVIS		
4		D2235-1	RIB		
	2	D2232-1	HINGE		
2		D2232-3	HINGE		
2		D2330-1	FRAME	84.00	45
2	2	D2330-3	FRAME	25.50	45
1		D2330-5	FRAME	32.75	90
1		D2330-7	FRAME	24.25	90
1	2	D2330-9	FRAME	24.00	90
	2	D2330-11	FRAME	83.27	45
	2	D2330-13	FRAME	23.63	90
	1	D2330-15	FRAME	33.00	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

## NOTES:

- MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE (REF. DART SPEC. M304TS0.075W/0.60)
- FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- WELD PER DART QSI 004
- ALL DIMENSION ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

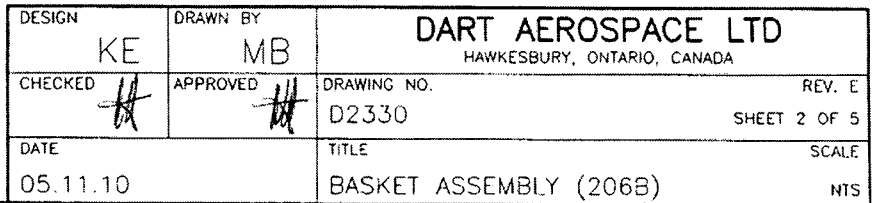
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WITHOUT NOTICE  
WORK ORDER  
NO. 40127B  
08.06.27  
UNDER REVIEW  
08/02.05 PH  
TUBING TO BE  
CHANGED TO 0.065  
WALL

RELEASED  
05-11-26

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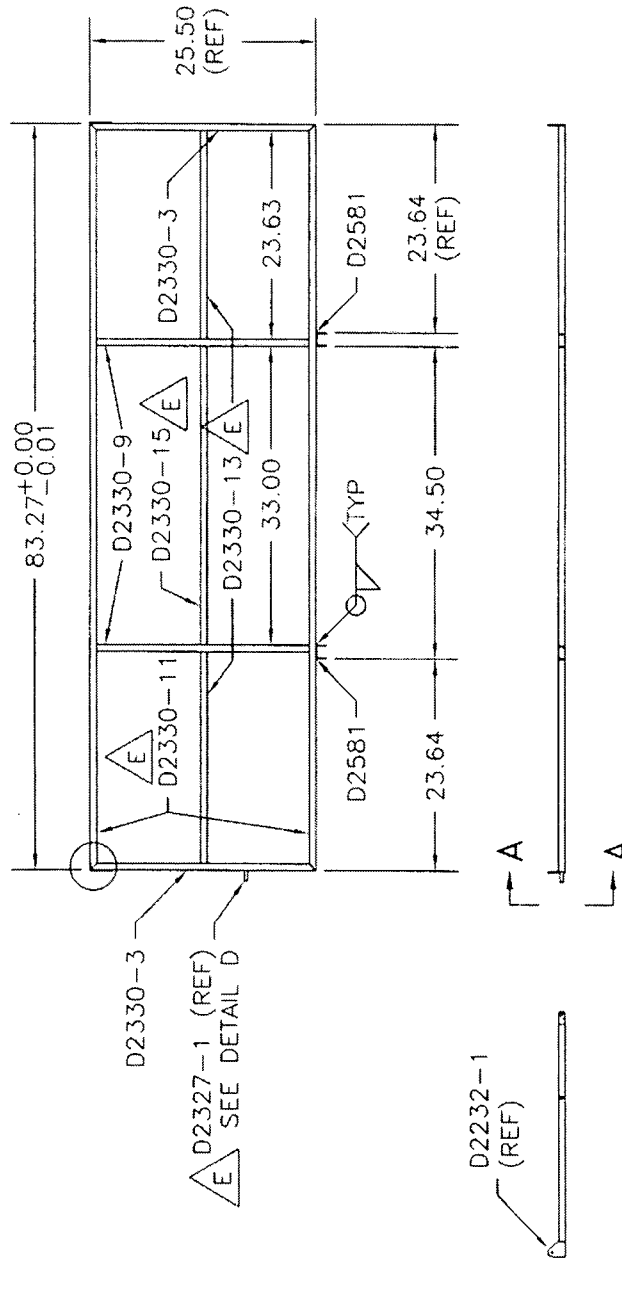


RELEASED  
05 11 26

**UNDER REVIEW**  
JAN 05 PM

~~TUBING TO BE  
CHANGED TO G-08S  
WALL~~

06.06.27



D2330-043 LID FRAME

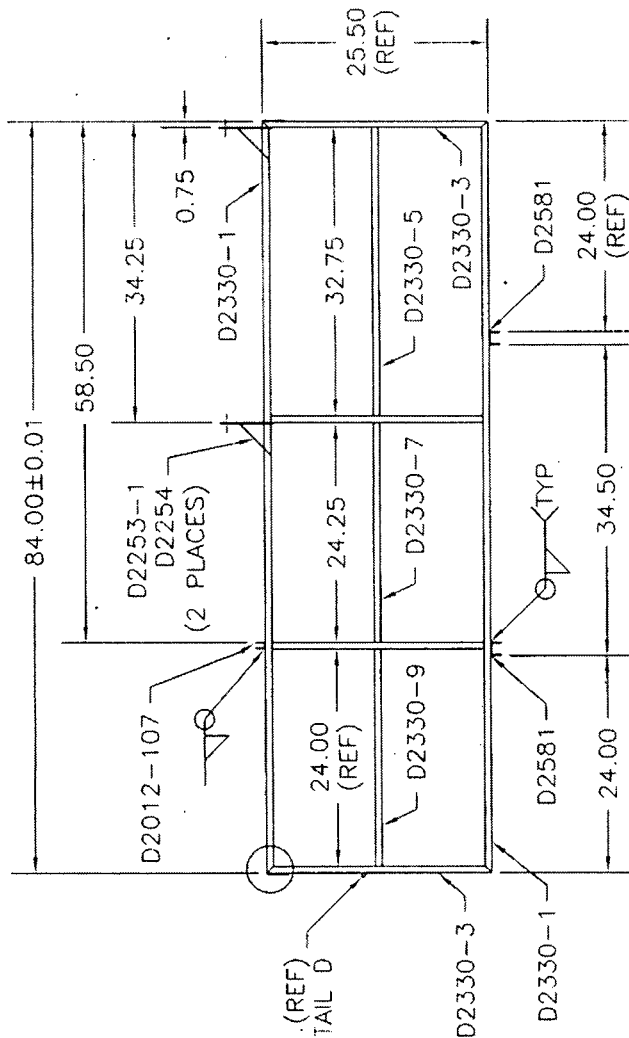
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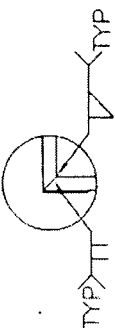
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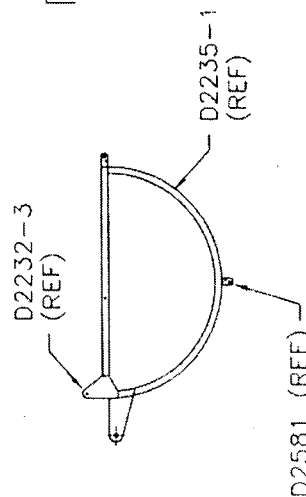
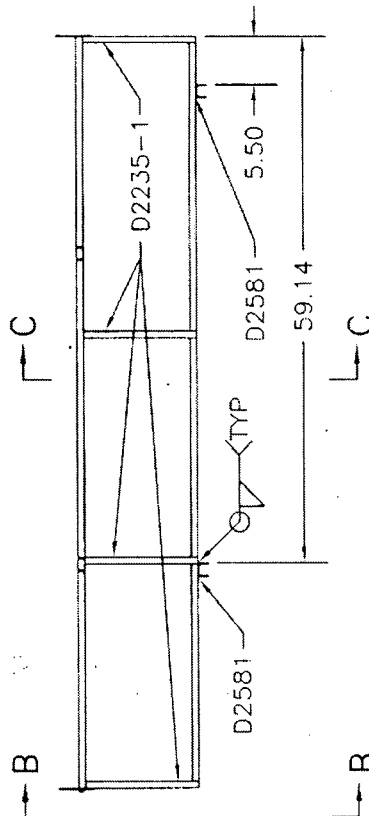
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CHECKED 	APPROVED 	DRAWING NO. D2330	REV. E SHEET 3 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS



WELD ALL JOINTS  
AS SHOWN



RELEASED  
05/11/2010



D2330-041 BASKET FRAME

UNDER REVIEW  
08.02.05

TUBING TO BE  
CHANGED TO 0.055  
WALL

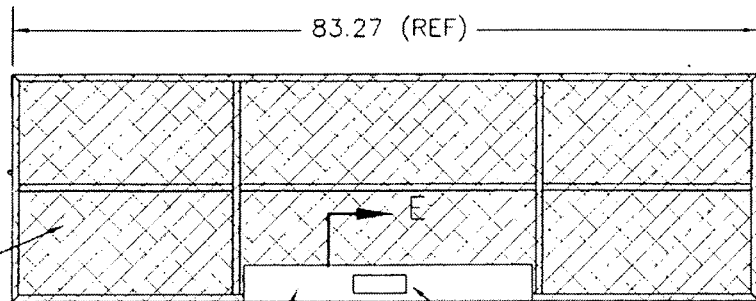
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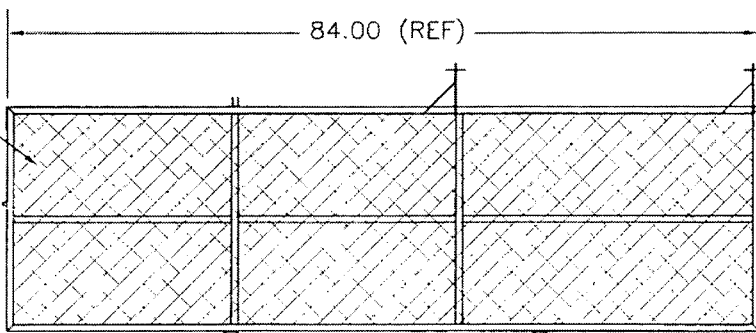
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SHEET 4 OF 5
		SCALE N/S	



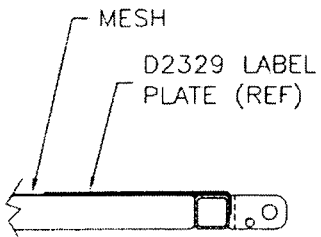
D2329 LABEL PLATE  
CENTER ON THE  
BASKET LID

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE

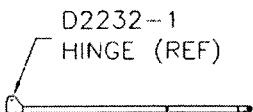
D2330-043 LID ASSEMBLY



D2330-041 BASKET ASSEMBLY

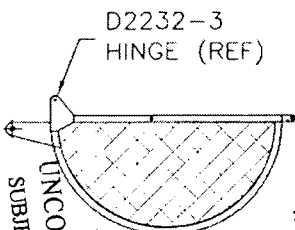


SECTION E-E



SKIN WITH 3/4-16 F  
EXPANDED SS, TACK  
WELD EACH STRAND  
END TO FRAME

RELEASED  
05-11-26

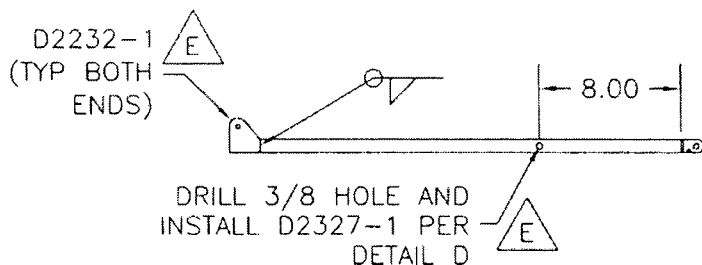
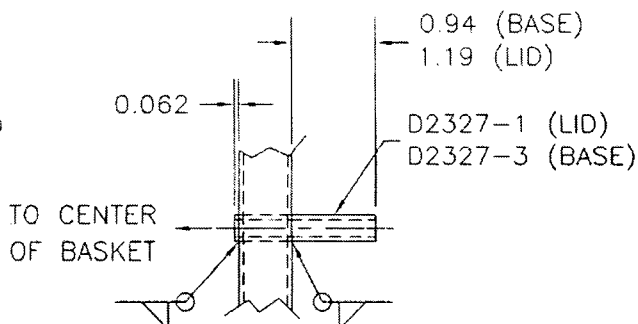
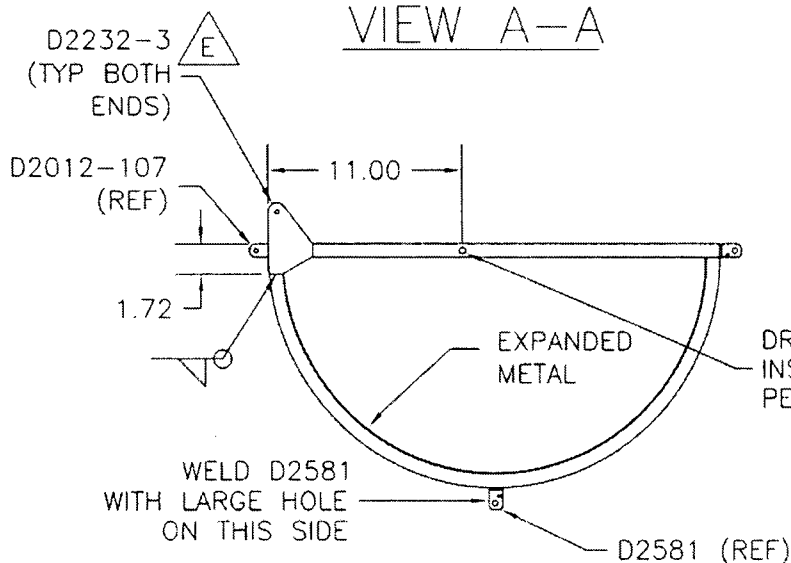
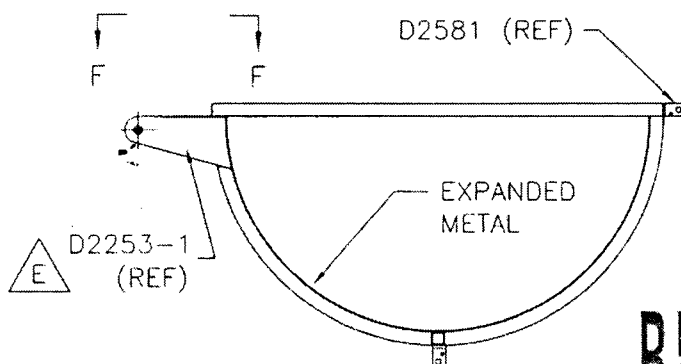
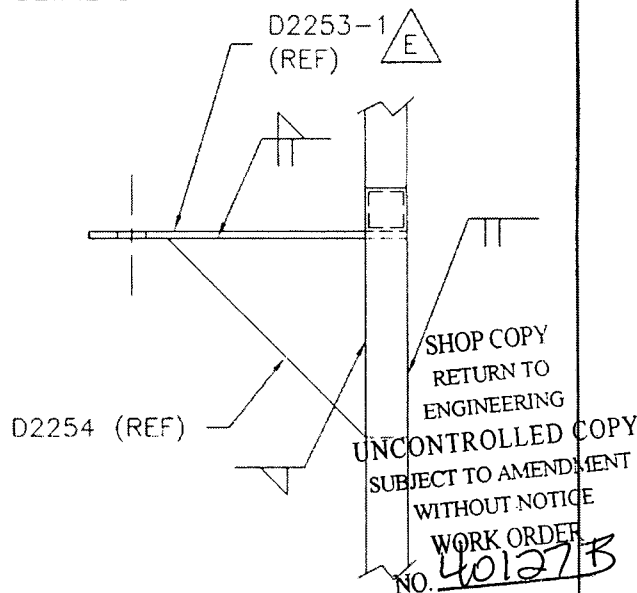


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UNDER REVIEW  
08.01.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL  
01.06.27

**DART**

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2330	REV. E SHEET 5 OF 5
DATE 05.11.10		TITLE BASKET ASSEMBLY (206B)	SCALE NTS

VIEW A-ADETAIL DVIEW B-BVIEW C-CVIEW F-F

**UNDER REVIEW**  
08.02.05 PH  
TUBING TO BE  
CHANGED TO 0.055  
WALL PH  
08.06.27

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05.11.26 *[Signature]*

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